



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61385

August 23, 2010 10:58:09 AM



Page 2

Item ID: D6101-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 8/23/10

Start Qty: 30.00



Cust Item ID:

Required Date: 9/03/10

Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

*mf 10/09/07*

30

*Ø*

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D

130

Identify as per dwg & Stock Location: *MAT*

0.00

*mf 10/09/07*

30

*Ø*

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

*10/09/08 mf*

QC

Memo

0.00

Quality Control

*mf 10-9-8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 23, 2010 10:58:09 AM

Page 1

Work Order ID: 61385



Parent Item: D6101-001



Parent Item Name: Saddle Billet


Start Date: 8/23/10

Required Date: 9/03/10

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP B: ☐01.05.04☐New Issue☐EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1	30			



CD 10/9/7 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

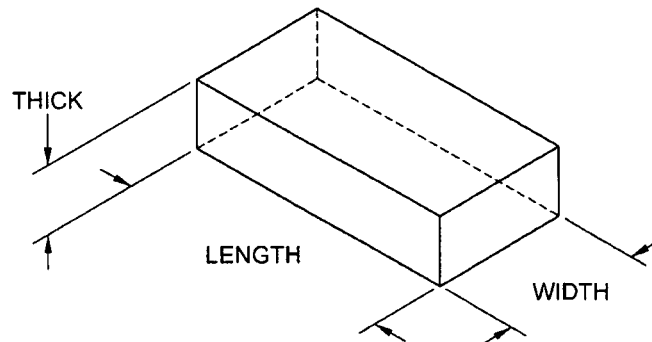
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

**B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

**RELEASED**  
09/07/15/W

CL1018123  
W10.61385

09/04/23

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**Castle Metals®**

A. M. Castle &amp; Co.

**PACKING SLIP**

Page 1 of 1

Shipment No:474379

<b>Ship From:</b> Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 02-SEP-10	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN		<b>BOL No</b> 474379-2	

<b>Shipment Details</b>				<b>Final Destination Branch - MON</b>			
<b>Order No</b> 950074	<b>Line No</b> 1	<b>Item No</b> 6857.MO	<b>Description</b> 2.0000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
<b>Purchase Order No</b> 12019		<b>Part Number</b> YOUR ITEM NUMBER: D6101-001		<b>Ordered Qty</b> 30 PCS		<b>Invoice Qty</b> 30 PCS	
<b>Details</b>							
<b>Delivery No.</b> 41482304	<b>Mill</b>	<b>Heat Number</b> 456750A9	<b>Mech Id</b>	<b>PCS</b> 30	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty (LBS)</b> 232.25

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
Reviewed by Authorized Castle Metals Representative:	Date:

C&amp; 10/19/13

and 10/19/07



## SHIP TO:

A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

# KAISER

## ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4149447

## SOLD TO:

AM CASTLE & CO- SOLD TO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-15905		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 101432/18		GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1075544		LINE ITEM: 1	SHIP DATE: 11-DEC-2008		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE		
WEIGHT SHIPPED: 5732 LB		QUANTITY: 4 PCS EST.		B/L NUMBER: 2020668		GAUGE: 2.0000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN

## Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
G8816100/RevG/Amd1

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 008/RevC  
GAMP8 9101/RevB  
PS 21211/RevK

Test Code: 4297

## Test Results

Lot: 456814A9 Cast 198

Drop 21

Ingot 1

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.2 : 73.8 (508 : 509)	63.6 : 84.9 (439 : 447)	11.6 : 11.8

(ASTM E1004)

Conductivity %IACS :	41.2 Min	41.7 Max
(MS/M) :	23.9 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.21	1.6	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.05

*Handwritten signature*  
10/10/07

**KAISER  
ALUMINUM**Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number  
4149447

Lot: 456750A9 Cast 188

Drop 20

Ingot 1

(ASTM E8/B667)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.1 : 73.7 (504 : 508)	62.7 : 83.4 (432 : 437)	11.9 : 12.1

(ASTM E1004)

Conductivity %IACS :	41.8 Min	42.2 Max
(MS/M) :	24.2 Min	24.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.22	1.4	0.02	2.4	0.20	5.7	0.03	0.01	0.01	TOT 0.05

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**TEST NOTES**

7075-T7351 plate 3.001-3.500" thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-1. 7075-T7351 plate 3.501-5.000" thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CASTLE METALS CORP.  
DATE RCVD 12/16/08  
IAC 685108  
APPROVED BY [Signature]

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 228.872-1(h), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR INTIMIDATION ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW, 180-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

[Signature]

